

Date: Thursday, 3/30/2006 10:06:15 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP SPACER		
Job Number	: 26452B					
Estimate Number	: 10378					
P.O. Number	: N/A			Part Number	: D30653	
This Issue	: 3/30/2006		S.O. No.	: N/A		
Prsh Rev.	: NC			Drawing Number	: D3065 REV. A2	
First Issue	: N/A			Project Number	: N/A	
Previous Run	: 26211B			Drawing Revision	: A2	
Written By	: <i>See comment below</i>			Material	: N/A	
Checked & Approved By	: <i>kg 06.03.30</i>			Due Date	: 4/15/2006	
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF			Qty:	60	Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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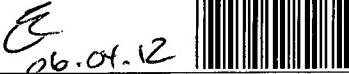
Comment: Qty.: 0.2287 sf(s)/Unit Total : 13.7214 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

(M2024T3S.040)

Batch: *B19659*
M19295

2.0	SHEAR	SHEAR
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Comment: SHEAR

Cut blank: 6.600" x 4.320" Grain along 4.320"

3.0	HAAS Water jet	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Cut Machine as per F001-EA180 and Dwg D3065

Stack of 15

Identify as D3065-3

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06.04.12

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

06.04.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		Modify step 2 & 3 as shown on p.1	E	06.04.12			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/05/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/30/2006 10:06:15 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 26452B

Part Number: D30653

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

rd 04/12 (56)

7.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D30653

SB 06/05/02 56

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/05/04 (56)

9.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAO 06/05/03 (56)

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

SB 06/05/03 56

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/05/03 56

12.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/04 (56)

Job Completion



W 06/05/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD	Work Order:	26452B
Description: Step Spacer	Part Number:	D3065-3
Inspection Dwg: D3065	Rev: A2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<i>M/ea</i>	Audited by:	<i>EZ</i>	Prototype Approval:	N/A
Date:	06.04.11	Date:	06.04.11	Date:	N/A

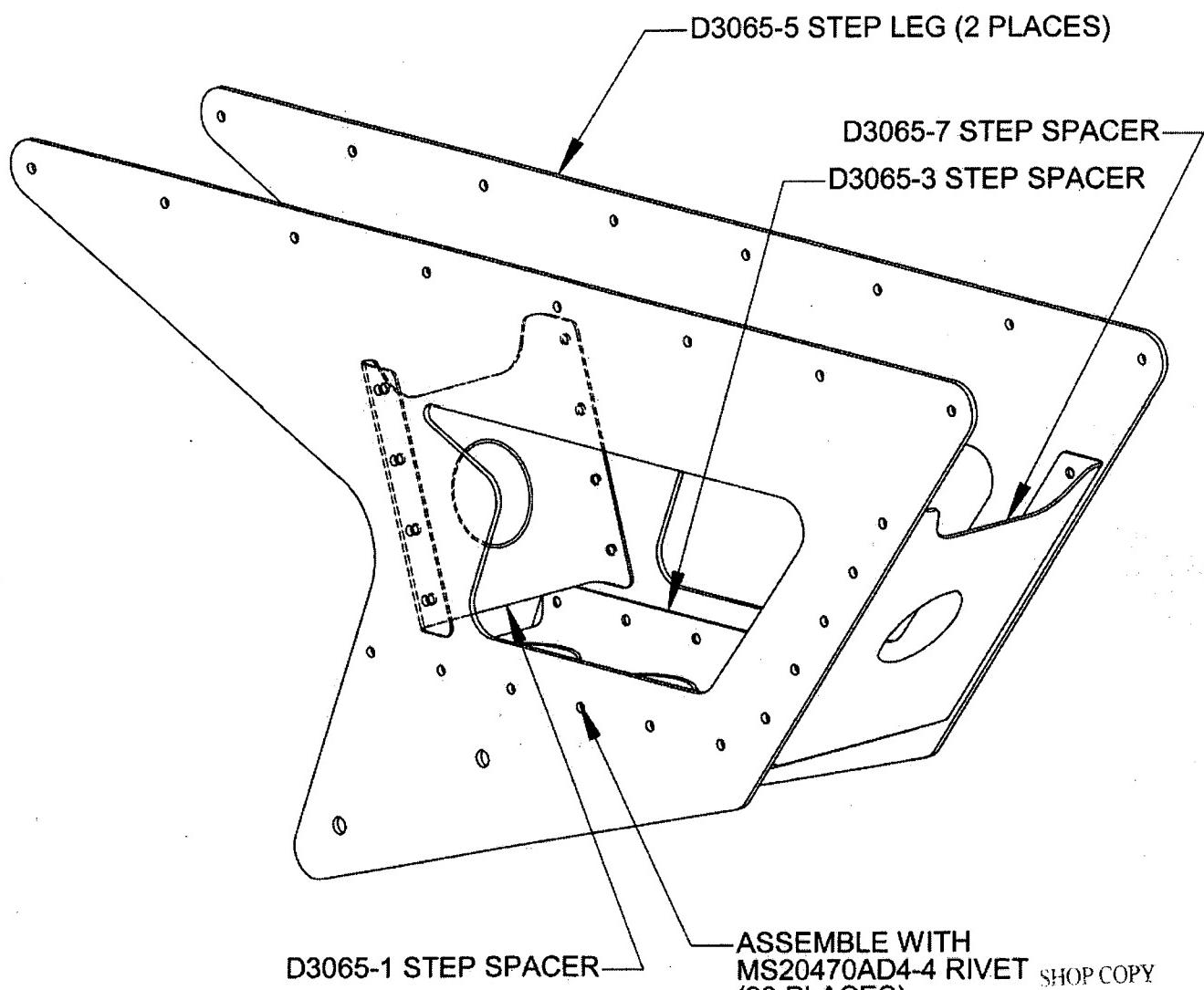
Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue P/O D3065-041	KJ/RF	
B	04.08.12	Removed dimension 1.204	KJ/JLM	<i>[Signature]</i>



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DATE	02.09.11	TITLE STEP LEG ASSEMBLY SCALE 1:2
A	02.09.11	NEW ISSUE
A1	03.02.13 GP	ADD SLOTS TO D3065-5
A2	03.02.27 GP	0.551 WAS 0.410

RELEASED
02.09.20



D3065-041 STEP LEG ASSEMBLY

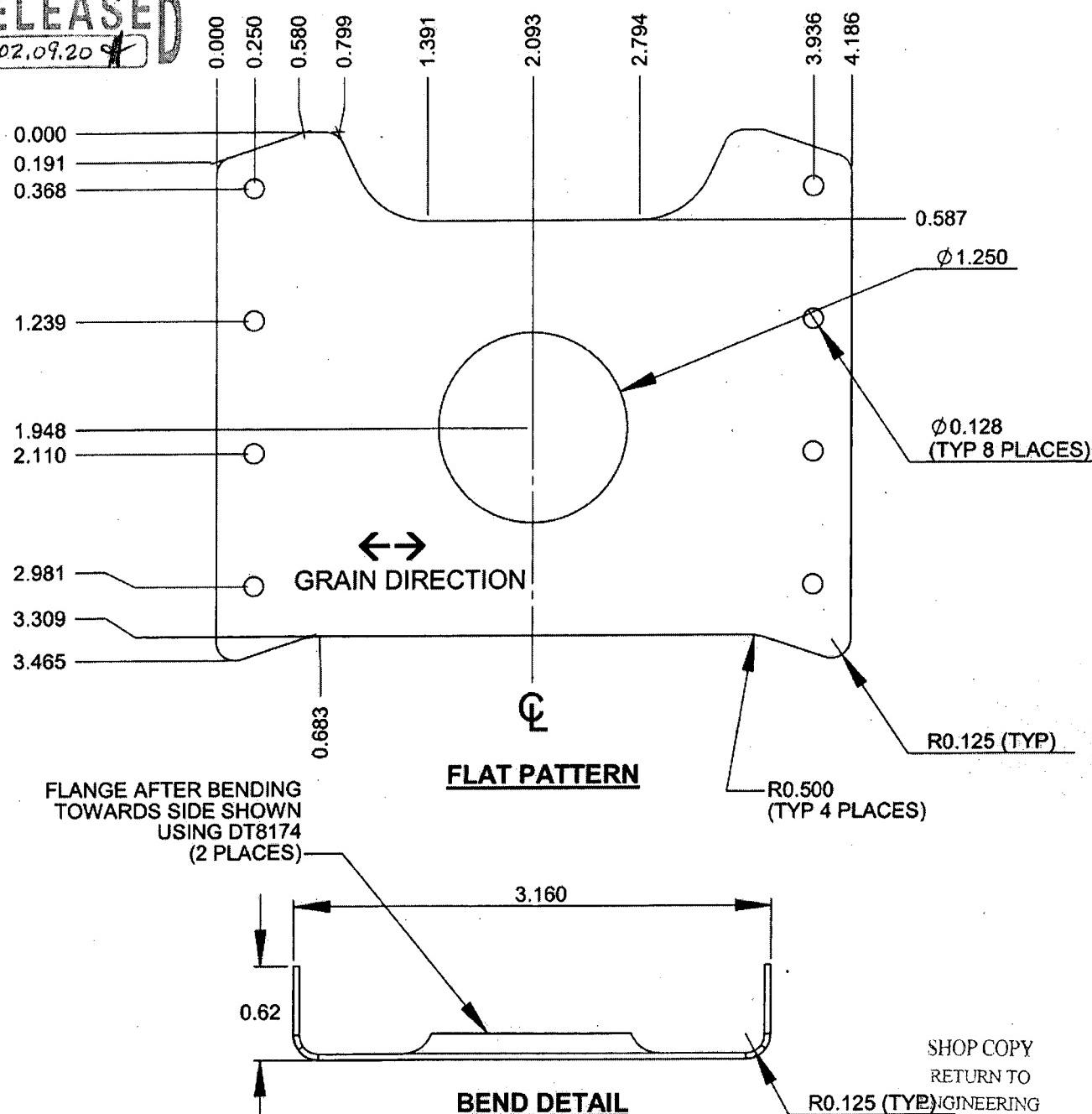
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DATE	02.09.11	REV. A SHEET 2 OF 5 TITLE STEP LEG ASSEMBLY SCALE 1:1

RELEASED
02.09.20**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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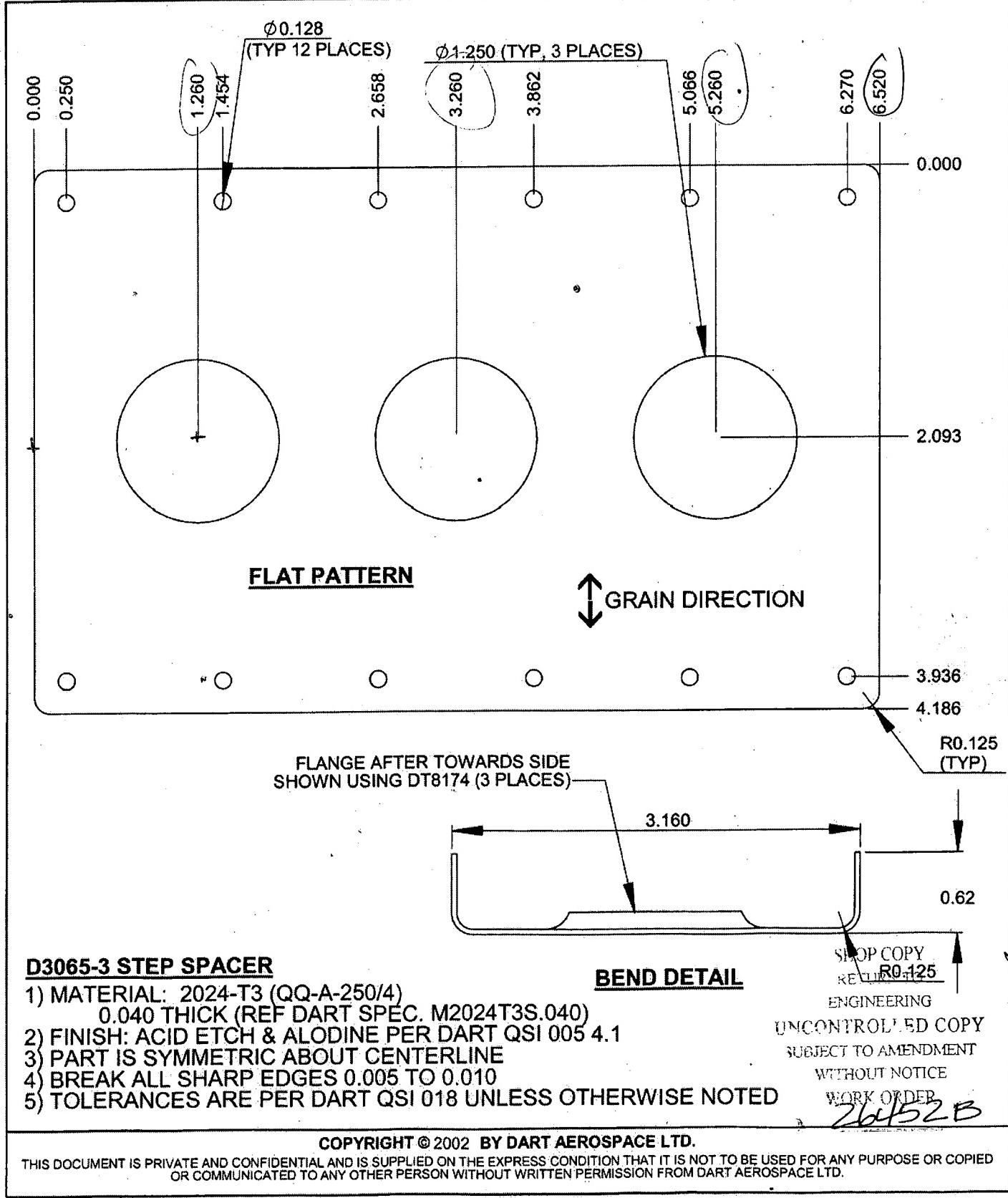
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DATE	02.09.11	TITLE	SCALE 1:1 STEP LEG ASSEMBLY

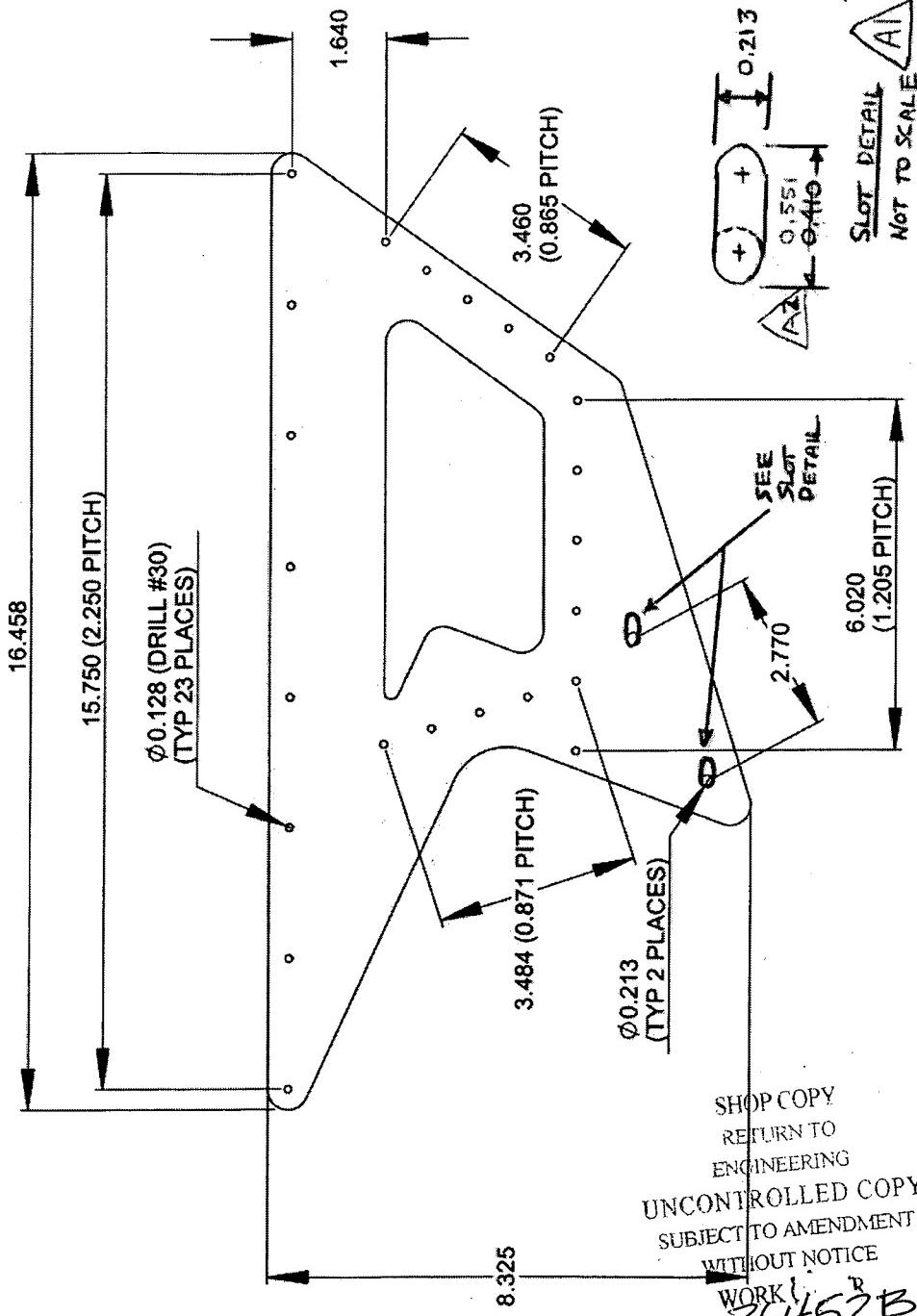




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DATE	02.09.11	TITLE	SCALE 1:3 STEP LEG ASSEMBLY

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02.09.2011



D3065-5 STEP LEG

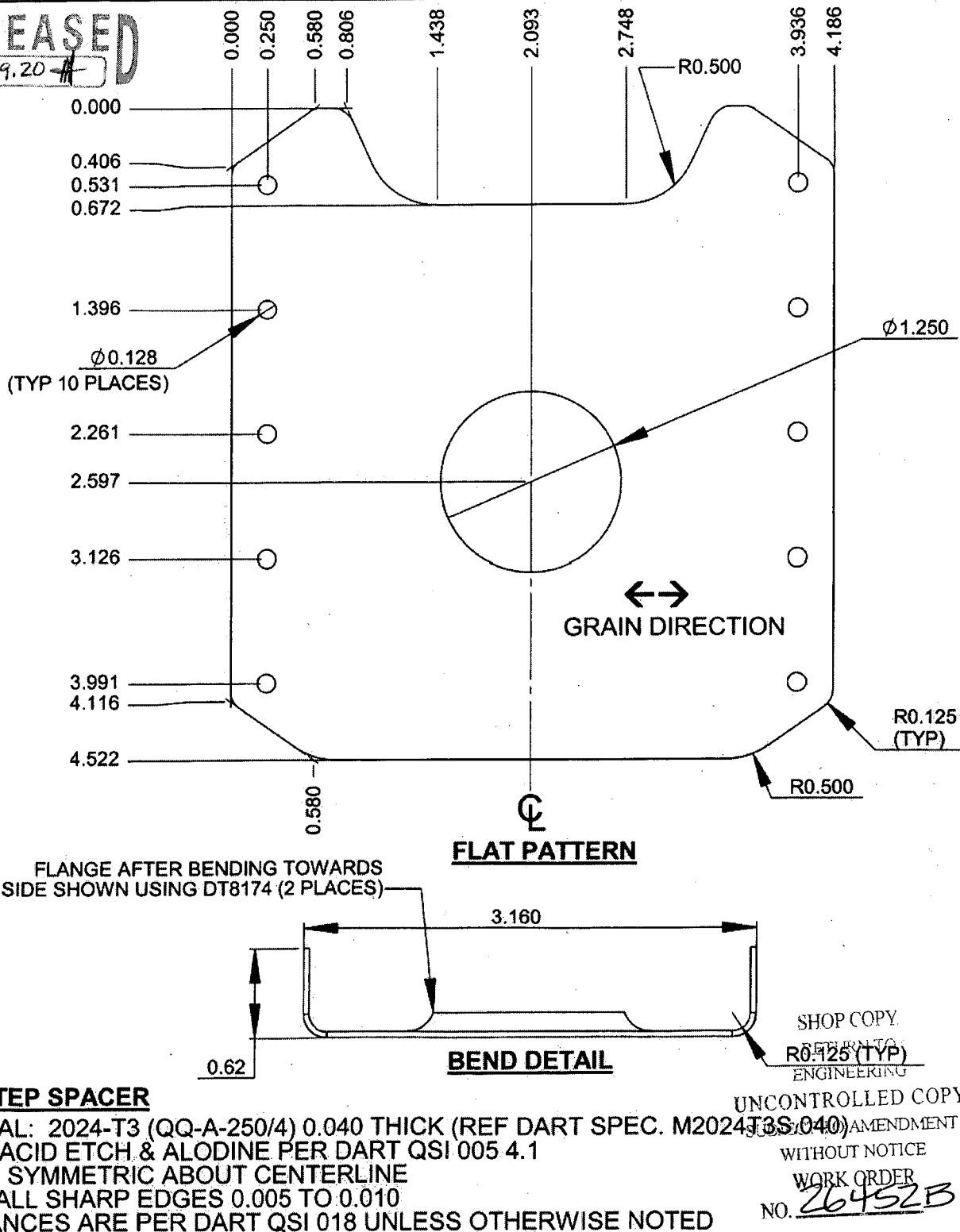
- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 0054.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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